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RBT400213
Job Sheet 186989



Part No: RBT400213

Job Qty: 1 ea 4

Part Name: 407 Trim Tab Bender



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400213 Rev F IPP Rev.A 17.09.22 New issue DP Verify DD IPP 17.11.23 Rev B TEO DP Verify DD
IPP Rev B 17.11.23 TEO DP Verify DD/IPP Rev C 18.03.08 DWG update Rev. F DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	2 pcs	1/11/19	1/11/19	0.00	2.00	Small Fab-9		MLC DAS
120	QC	2 pcs	1/11/19	1/11/19	0.00	0.00	QC5		DAS 2019 68
130	Packaging	2 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		28 9-89
140	QC21-FG	2 Ea	1/11/19	1/11/19	0.00	0.00			9-89

Part Op 90 - See engineering for hardware sign off. ***Was AN426AD-4-8, IS MS20426AD4-8. Was AN470AD-4-7, IS
Descriptions: MS20470AD4-7. WAS AN350-4, IS MS35426-14.***

110 - Assemble as per DWG. Hand tighten only

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
136 RBT400213-1	Tab Bender Body	4 2 Ea (1 ea)	90-Start up Operation	3103351
136 RBT400213-7	Top Tab Assembly	4 2 Ea (1 ea)	90-Start up Operation	3135523
73 RBT400213-9	Pointer	4 2 Ea (1 ea)	90-Start up Operation	3103917
st 311- MS20426AD4-8	Rivet	16 8 Ea (4 ea)	90-Start up Operation	18136-4
st 310 MS20470AD4-7	Rivet, Universal Head	8 4 Ea (2 ea)	90-Start up Operation	3048900
st 269 MS35426-14	SS Wing Nut	16 8 Ea (4 ea)	90-Start up Operation	3134432XB Y1
st 262 NAS1149F0432P	Washer	16 8 Ea (4 ea)	90-Start up Operation	5131202

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MS20426AD4-8	8	2,371	0
	MS20470AD4-7	4	1,550	0
	MS35426-14	8	42	0
	NAS1149F0432P	8	650	0
	RBT400213-1	2	15	0
	RBT400213-7	2	0	0
	RBT400213-9	2	15	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

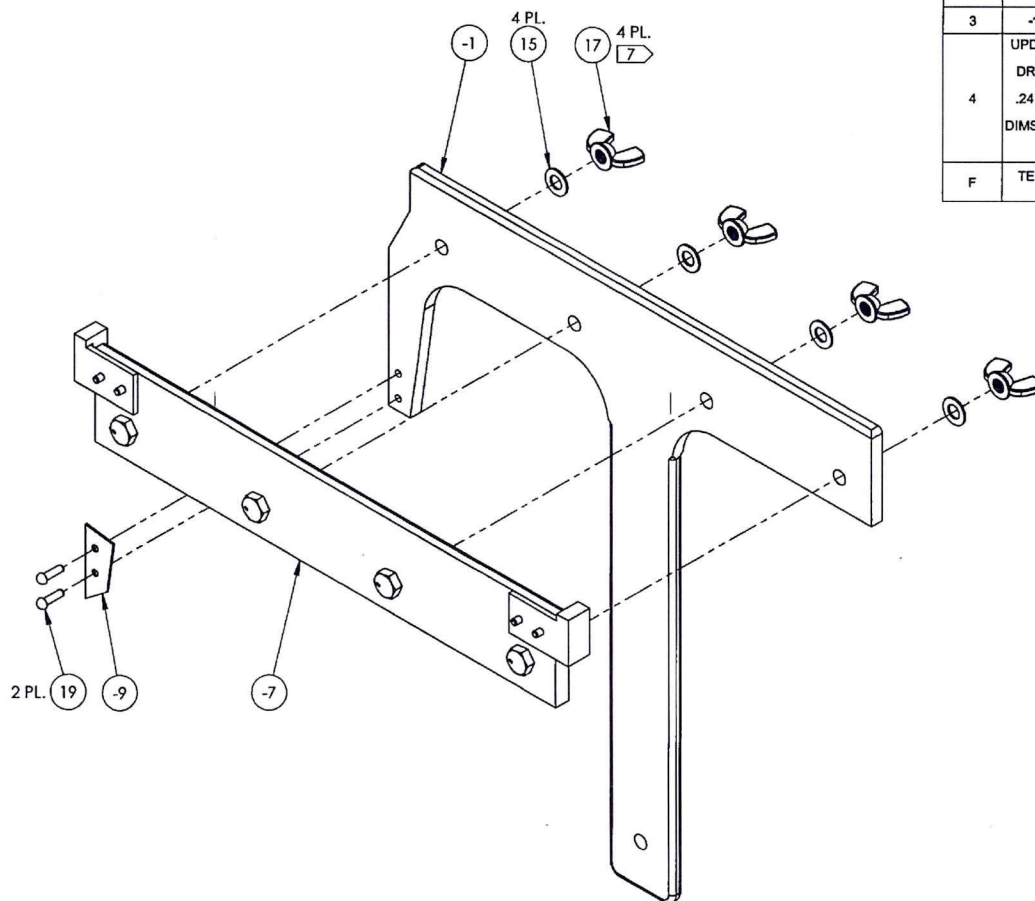
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM #	QTY	PART #	TITLE	PG
-1	1	RBT400213-1	TAB BENDER BODY	2
-7	1	RBT400213-7	TOP TAB ASSY	3
-9	1	RBT400213-9	POINTER	7
15	4	NAS1149F0432P	WASHER 1/4"	-
17	4	AN350-4	WING NUTS 1/4"-28	-
19	2	AN470AD-4-7	HEAD RIVET 1/8" x 7/16"	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D DWG. NO. FROM 407-215-001-101, CH'D DESCRIPTION IN BOM P/N -1, -3, -4, -5.	-	6/18/2009	RJC	-
1	ADDED -9 & -19, CH'D DESIGN -1 PER S.E. SEPARATED PARTS TO INDIVIDUAL SHEETS, CREATED ASSY. DWG. & -7 ASSY. DWG.	-	4/27/2011	RJC	-
2	CH'D -1 CHAMFER FROM 1/16" & CH'D FINISH FROM POWDER COAT YELLOW ADDED -5 FINISH PER R.W. MOVED #30 HOLE TO BE SYMENTRICAL WITH RIGHT SIDE PER S.E. DELETED -7 FINISH & NOTE 2 PER R.W.	-	8/25/2011	RJC	RW
3	-1 CH'D TWO HOLES DIM'S, WAS R.064 (x2) IS Ø.125 (X2).	-	12/26/2013	RJC	GE
4	UPDATED TO NEW DRAFTING STANDARDS, -1 CH'D DIM WAS .250 IS (250), -3, -4 CH'D DIMS WAS DRILL #30 THRU X2 IS 2X Ø.129 THRU, WAS .500 IS (.500), -5 CH'D DIM WAS DRILL #30 THRU CSK 100° X .24 OD 4 PLACES IS 4X Ø.129 THRU Ø.24 X 100°. -7 CH'D DIM WAS 11.580 IS (11.580), -9 CH'D DIMS WAS 1.051 IS (1.051), WAS .801 IS (.842), WAS .301 IS .347. ADDED DIMS (.311), (.381), .500, CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	15-0021	1/26/2015	DPD	JAG
F	TEMPLATE UPDATED, NOTE 7 ADDED, ITEM 15 AN960-416L WASHER CHANGED FOR NAS1149F0432P	17-797	17.12.21	VM	ML



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) HAND TIGHTEN ONLY

RBT400213 407 TRIM TAB BENDER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186989 MLC
18711-23

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE 407 TRIM TAB BENDER	
PART NO. RBT400213	REV F
TOOL NO. RBT400213	
INITIALS AND DATE	
DESIGNED BY: VM 12/21/2017	TOLERANCES: XXX ± .005
DRAWN BY: VM 01/02/2018	XX ± .01
CHECKED BY: VM 01/02/2018	X ± .1
MFG REVIEW BY: DD 01/02/2018	SCALE: NTS
APPROVED BY: ML 01/30/2018	SHEET 1 OF 7
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Container No: S142784



Part: RBT400213

Job No: 186989

Serial No/Batch: S142784

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 01/08/19